

Work Order ID 166152

Tuesday, September 12, 2017 9:53:45 AM

166152

Page 1

Item ID: D4021-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Blanking Plate
Start Date: 9/12/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 9/15/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: SEP 12 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4021	B
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100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg D4021

Prog Rev: BDwg Rev: B

Deburr as required

0.38

17/09/13DAS
40
9-89

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.10

17/09/13DAS
40
9-89

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.20							DAS 9 9-89
Quality Control									
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.30							
Powder Coating									
135	QC3- Inspect Part Finish	0.00							
135									
QC	Memo	0.10							DAS 9 9-89
Quality Control									

START: 10:40.
 OV. T: 400°
 FINISH: 11:10.

100 SEP 14 2017
 10 17-09-15. 94 9-89
 17-09-15

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: 57068 Memo	0.00 0.10				10	SEP 18 2017		ref
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 1.00					17 9/20/17		SEP 18 2017

Picklist Print

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Parent Item: D4021-5

D4021-5

Parent Item Name: Blanking Plate

Start Date: 9/12/2017

Required Date: 9/15/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB
DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

73.4000

0.0622

0.654737

M304S16GA

**

17/09/13

DAS
40
9-89

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT010

73.4

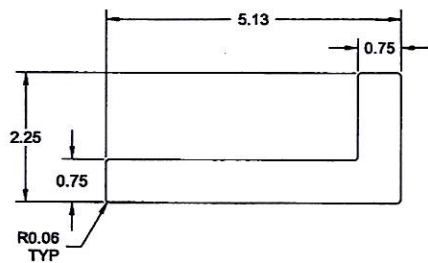
m138175

29.9

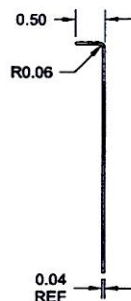
m138346

43.5

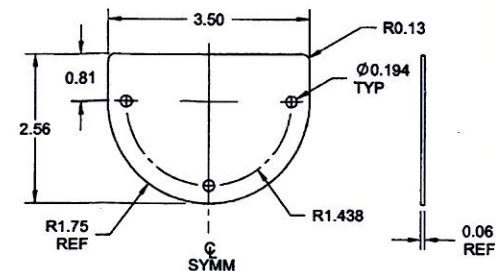
2.7



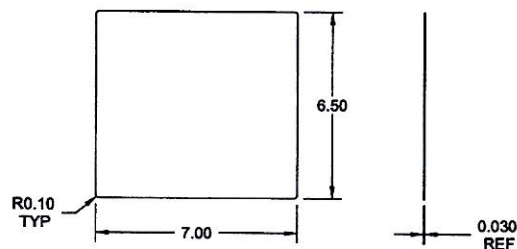
D4021-1 HANDLE PLATE



D4021-3 DATA PLATE
MAKE FROM D4021-3F

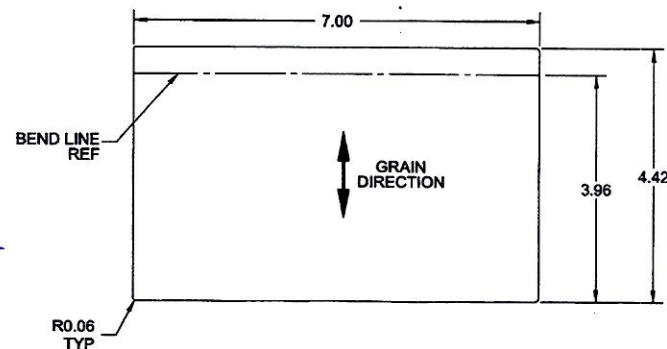


D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166152 MWS
1709-12



D4021-3F DATA PLATE
FLAT PATTERN

RELEASED
R 2010-04-14
NP

NOTES:

- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
- 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

- 2) FINISH: -1/-3/-11: NONE
- 5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.18 lbs -3: 0.35 lbs
- 5: 0.14 lbs -11: 0.39 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4021	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD.	
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